

Ship 26/07

Dart Aerospace Ltd.

30

Date: Monday, 7/9/2007 12:44:50 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY  
 Job Number : 33406  
 Estimate Number : 10022  
 P.O. Number : NIA Part Number : D205634011  
 This Issue : 7/9/2007 S.O. No. : NIA Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : LANDING GEAR Drawing Revision : N/A  
 Previous Run : 33405 Material : NIA  
 Due Date : 7/26/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.07.09  
 Comment : Est Rev P 02.08.28 Removed QC5 from Step 5 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D205-634-011 CHG005

KS 07.07.09

2.0 33406A w/ ss wezplds SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 33406A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

B31129

P 1/2/2 7 C

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 07/07/27 C

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location:

EP 07/07/27 C

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:44:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 33406

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/07/30

Job Completion



*Handwritten signature/initials*

B 33406 A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Ship 26/07

Dart Aerospace Ltd.

30

Date: Monday, 7/9/2007 12:45:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 33406A  
 Estimate Number : 10023  
 P.O. Number : *N/A* Part Number : D205634041  
 This Issue : 7/9/2007 S.O. No. : *N/A* Drawing Number : D2580 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 33405A Material : *N/A*  
 Due Date : 7/26/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : *07.07.09*  
 Comment : Est Rev: M 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev. O 06.02.28 Added paperwork EC  
 Est Rev: P 07-07-09 SS Wearplates & Gaskets JLM *✱*

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002 *N/A*

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion *B294002*

*DP 7-7-11*

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2596 205 Web *B33088*

*R 7-7-11*

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

*DP 7-7-11*  
*7-7-11*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	M104732	
Sikaflex expire date: 9-1-1			
Start Time: 2:30		Date: 7-7-11	
Fin Time: 2:40		Date: 7-7-11	

DP 7-7-11

R 7-7-11

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-7-12

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

R 7-7-16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-07-14

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B31925

BE 07-07-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

*BE 32026*

*BE 07-07-16*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

*BE 07-07-16*

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*M104907*

*BE 07-07-16 17*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*M104907*

*BE 07-07-16*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*M104907*

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

*M104907*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*M104907*

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

*M104907*

8-Drill pilot holes for Tow ring using DT8091, open to 5/64" and Deburr

*M104907*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*12/07/07/19*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*12/07/07/19*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: HAND FINISHING RESOURCE #1  
Pressure wash as per QSI 005

m-l

07/07/25

14.0

POWDER COATING

POWDER COATING



②

Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 105068

B/M/07-07-25

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



③

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

FL

07/07/26 ①

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Cap  
Batch: B 27488

m-l

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Bolt  
Batch: M100188

m-l

18.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Washer  
Batch: M103641

m-l

19.0

ALS71032130

Insert



④

Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)  
Insert  
Batch: M103495

m-l 07/07/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/25	#14	New holes were not drill <del>for</del> for wear plate #D3566-B. It was found when wear plates were installed it was missed due to unclear work and experience was missed by inspectors as well	QS/042	- Drill out holes in <del>AD</del> <del>end</del> of tube with DT 893F - Touch up holes with enamel paint as per QSI OOS ADD DT 893F to step #10.5 for wear plates	<u>Mr. J</u> <u>07/07/25</u>	Ep <u>07/07/25</u>	QS/042	Ep <u>07/07/25</u>

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

*150 x AN960C10L*

Description:

*B M105057*

*\**

20.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch:

*M104955*

*m.d*

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

*B31399*

*m.d*

22.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

*B31421*

*m.d*

23.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch:

*B33458*

*m.d*

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

*B31398*

*m.d*

25.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

*B33455*

*\**

26.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

*B33457*

*m.d*

*\* ① 07/07/26*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

27.0

D35645

WEARSHOE



\*

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B 32054

28.0

D25943

O-Ring



\*

Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch:

B 27168

29.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch:

B 32651

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M 104989

Sikaflex expire date: 08-01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M 104989

Sikaflex expire date: 08-01

5-Wing Walk as per Dwg D2580 and QSI 005 4

M-L 07/07/27

Batch:

M 104942

①

m-h  
07/07/26

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 06/13/0  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 7/9/2007 12:45:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 33406A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



*EV 07/27/27* (XL)



*Ad plug  
in tube*

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*PPP 33406 07/27/27*

33.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

*07/27/30*

Job Completion



*u 07/27/27*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN #	DRAWN BY RH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED  
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

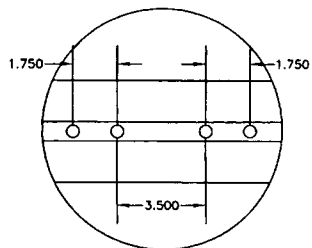
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33406A

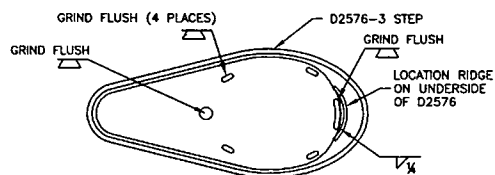
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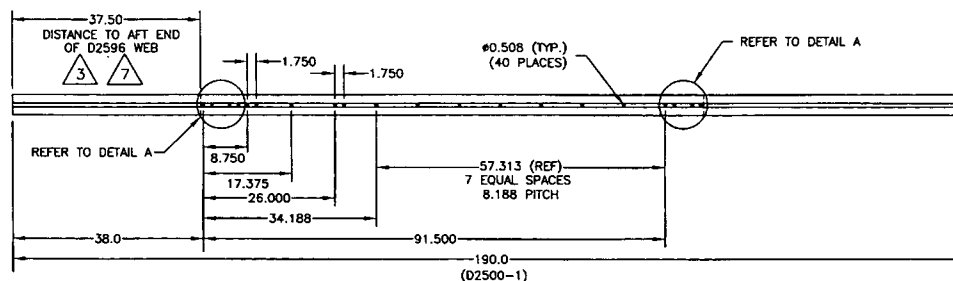
**DETAIL A**  
SCALE 5:24



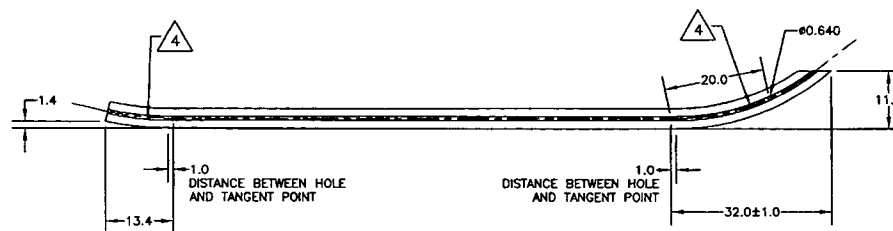
**DETAIL B**  
SCALE 5:24



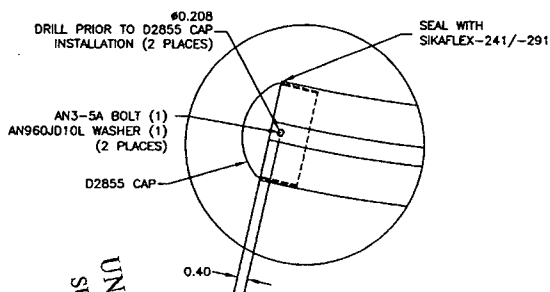
**D2580-1 DRILLING DETAIL**



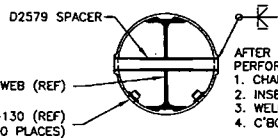
**D2580-1 BENDING AND CUTTING DETAIL**



**DETAIL C**  
SCALE 5:24

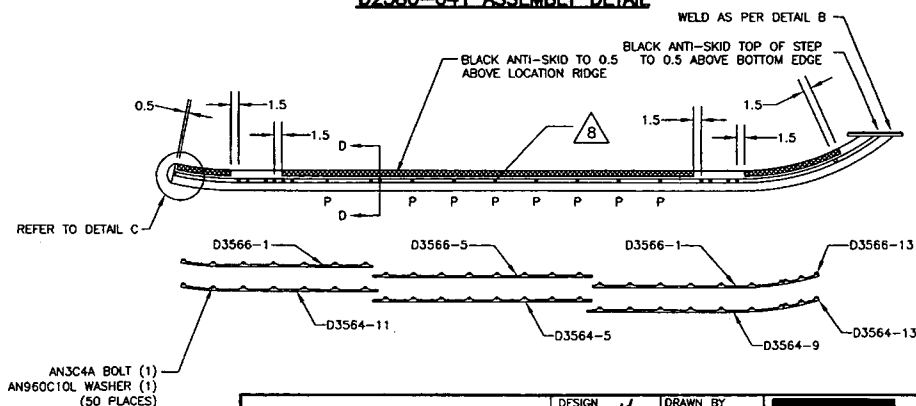


**SECTION D-D**  
SCALE 5:24



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2579 SPACER (20 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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APPROVED *[Signature]*

DATE

07.02.27

**DART**

**DART AEROSPACE LTD.**  
HARRISBURG, ONTARIO, CANADA

DRAWING NO.

D2580

TITLE

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 2 OF 3

SCALE

1:24

NO. 334906A  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
334906A

RELEASED  
07-02-28

RELEASED  
07-06-28

Diagram illustrating the underside of the D2576-3 step. The diagram shows a rectangular component with rounded corners. Key features labeled include:

- GRIND FLUSH (4 PLACES): Four locations on the underside of the component where grinding is required.
- GRIND FLUSH: A specific grinding location on the underside of the component.
- LOCATION RIDGE ON UNDERSIDE OF D2576: A ridge feature on the underside of the component.
- D2576-3 STEP: The component being illustrated.

#0.208  
DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

SEAL WITH  
SIKAFLEX-241/-291

AN3-SA BOLT (1)  
AN960JD10L WASHER (1)  
(2 PLACES)

D2855 CAP

SEE NOTE ii)

D2579 SPACER

D2596 WEB (REF)

107-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WE
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985

51.340

39.580

5.915

0.508 (8 PLACES)

20.0

0.640

1.4

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

13.4

3.630 (REF)

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

32.0 ± 1.0

12'

**HULL ASSEMBLY DETAIL**

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN96OC10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY	
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

NO. 116

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A205634041/B32617A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/16 Qualifier David A. Aival